

Date: Tuesday, 10/06/2008 8:52:03 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR PANEL
Job Number	: 39744		
Estimate Number	: 11401		
P.O. Number	:	Part Number	: D32961
This Issue	: 10/06/2008 S.O. No. :	Drawing Number	: D3296 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 37038	Material	:
Written By	:	Due Date	: 17/06/2008 Qty: 15 Um: Each
Checked & Approved By	JW08.6.10		
Comment	: Est C 05.10.14 Added step 14 KJ/EC Est Rev:D Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.6926 sf(s)/Unit Total: 10.3887 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)
 Identify for D3296-1
 Batch: ~~108415~~ 108415
 IB 8-7-2

MAT NOT PULLED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3296
 Dwg Rev: A
 Prog Rev: A

IB 8-7-2

(16)

2-Deburr if necessary

IB 8-7-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/07/02 (16)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

u/a

Done at step #22

S 08/07/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 8:52:03 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR PANEL

Job Number: 39744

Part Number: D32961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



16X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l 08/07/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/07/02 16

8.0

PACKAGING 1

PACKAGING RESOURCE #1



16X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 180

8/7/2

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-03

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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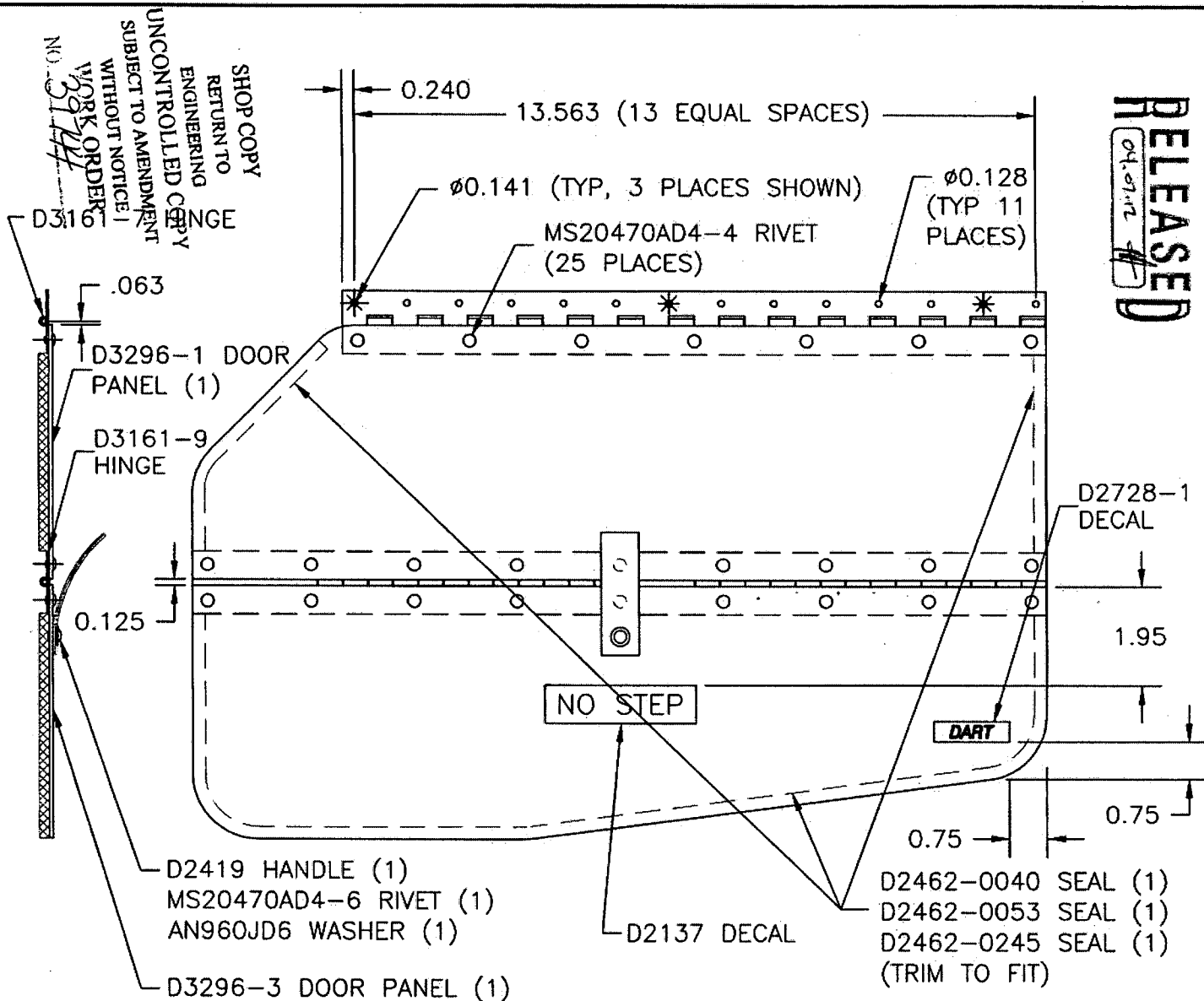
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. A
DATE		TITLE	1 OF 2
04.06.28		DOOR ASSEMBLY	SCALE
A	04.06.28	NEW ISSUE	1:3

RELEASED
04.07.12



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

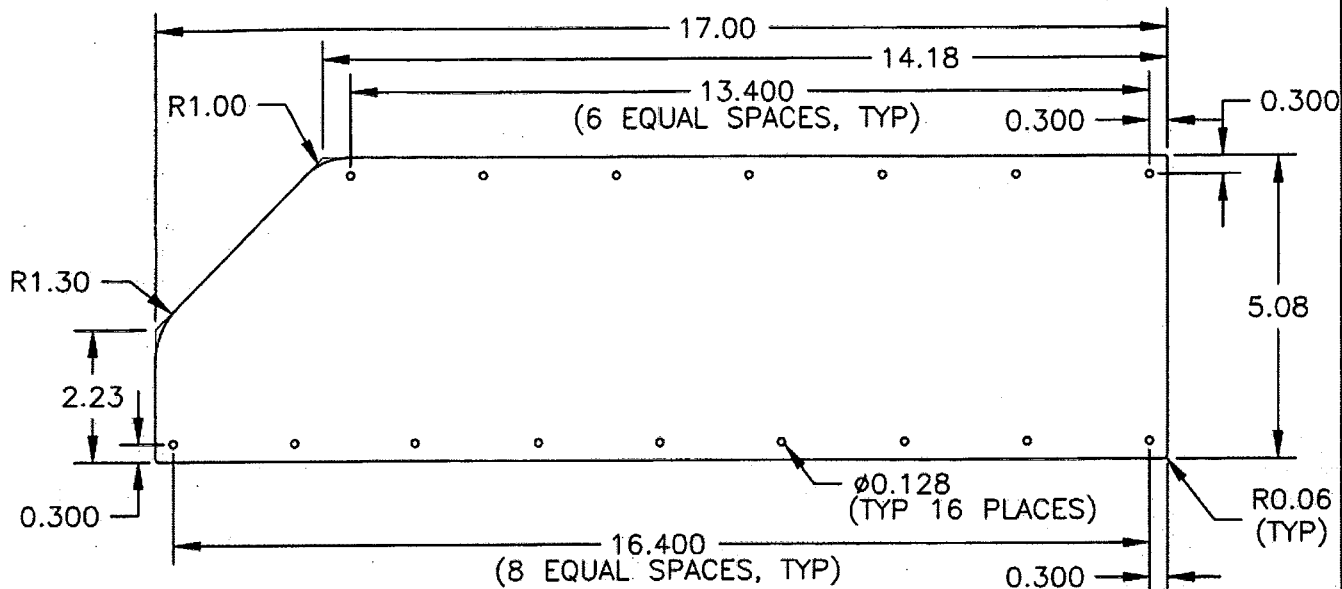
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

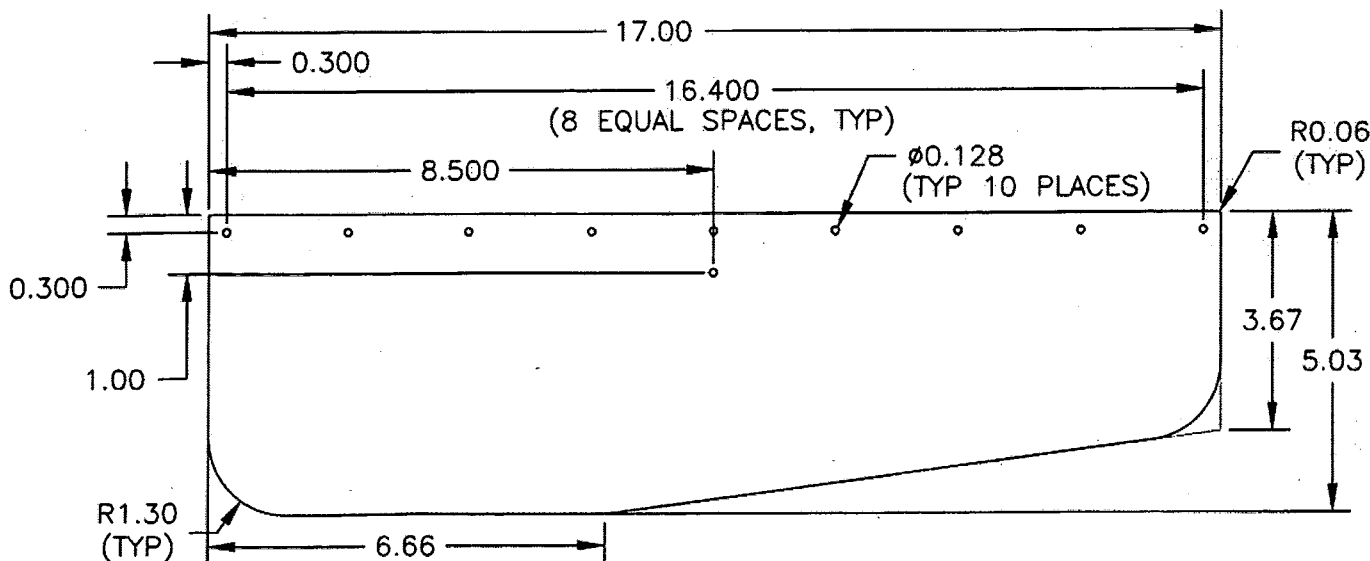
NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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WORK ORDER
NO. *5117*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries